

Work Order ID 85725

Thursday, June 14, 2012 11:12:40 AM

85725

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Item ID: D2365

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Wearplate

Stop

NS2

Start Date: 6/14/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2365

Rev C

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2365 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

6061, 063"

4

0

Jm 12-6-14

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4

0

Jm 12-6-14

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/17/2012

24

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Item ID: D2365 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate
Start Date: 6/14/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/15/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Small Fab	0.00							
150									
Small Fab	Memo	0.00							
Small Fab	Install Insert as per Dwg D2365								

4 7/6/12-6/15

(4)

8/12/06/15

4 p 12-06-15

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Item ID: D2365

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 6/14/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

E, 206-15

Picklist Print

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Work Order ID: 85725
Parent Item: D2365
Parent Item Name: Wearplate

Start Date: 6/14/2012 Required Date: 6/15/2012
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
(IPP Rev:B Now On Waterjet 08-04-04 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2365 FE-832-EF		Purchased	No	82502		100	Each	0.0000	2	8	4		
PEM Insert													
M6061T6S.063		Purchased	No			150	sf	557.2068	0.0047	0.0197895			
6061-T6 .063 Sheet													

FF 12-06-15
JM
12-6-14

Location	Loc Qty	Loc Code
MAT021	557.2068320	
113608	0	
116308	5.01556842	
117285	67.544	
119331	44.2	
119802	9.94	
120218	19.34	
120866	66.1026316	
121805	345.064632	

120218

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

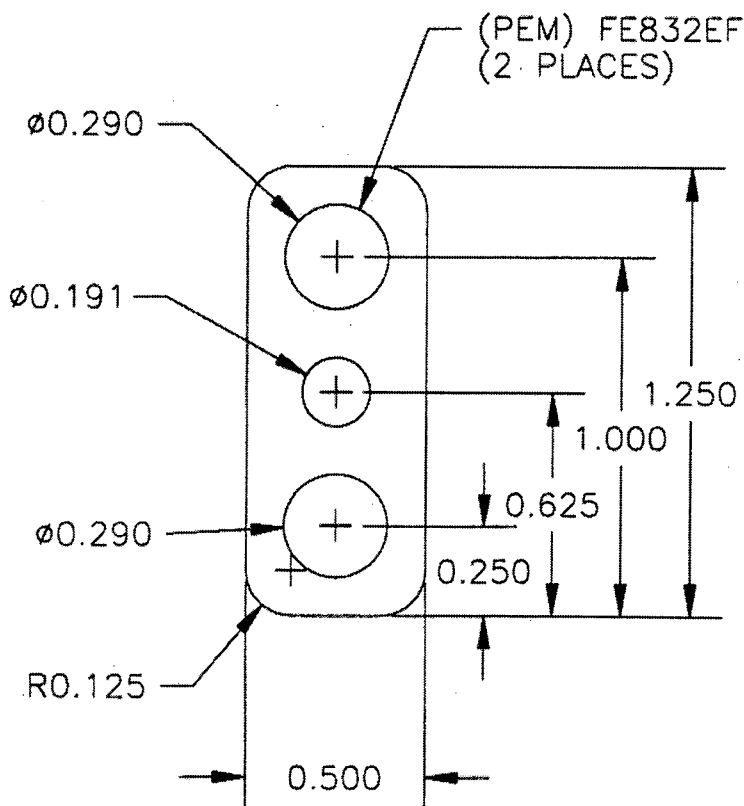
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B.W.	APPROVED [Signature]	DRAWING NO. D2365	REV. C SHEET 1 OF 1
DATE 95:01:20		TITLE WEAR PLATE	SCALE 2:1
C	95:03:06	0.191 WAS 0.197	

RELEASED
97/04/22 DS



6061-T6 (00-A-250/11) 0.063 THICK } # 00.09.26
ACID ETCH & ALODINE PER QSI 005 4.1.1 } #
INSTALL FE832EF (2 PLS) AFTER ALODINE } # 00.03.07
~~AKSI 304/316 SS~~
MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK
AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES } #

